


Date: Tuesday, 1/3/2006 4:15:06 PM
User: Kim Johnston

Process Sheet

SLIP-1

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE BILLET
Job Number	: 25354 - 4		
Estimate Number	: 10035		
P.O. Number	: N/A	Part Number	: D6101007
This Issue	: 1/3/2006 S.O. No. : N/A	Drawing Number	: D6101 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 25353	Material	: N/A
Written By	: 	Due Date	: 7/15/2006
Checked & Approved By	: _____	Qty:	40 / 100 Um: Each
Comment	: Est. A: 01.05.04 New Issue EC		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 00000339

06/01/04

- a) Description: Alluminum billet
- b) 7.750" x 8.250" x 2.50" thick
- c) Tolerance on all dimensions are +0.030"/-0.000"
- d) Grain direction along 7.750" length
- e) Material: 7075-T7351 (QQ-A-250/12)
- f) Material certification required

2.0 D6101007 7075-T7351 8.25X7.75X2.5



Comment: Qty.: 1.0000 Each(s)/Unit Total: 100.0000 Each(s)
7075-T7351 8.25X7.75X2.5

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

- Receive & Inspect For Transit Damage
- Ensure material certification is attached

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK
Ensure Material certification comply to Dwg D6101

U4/11/29(40)
P.D. 06/01/04

7ml 06/01/30 40



Process Sheet

Order: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE BILLET

Job Number: 25354

Part Number: D6101007

Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

6/4/25 *(40)*

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

(40)
2006/11/30

Job Completion

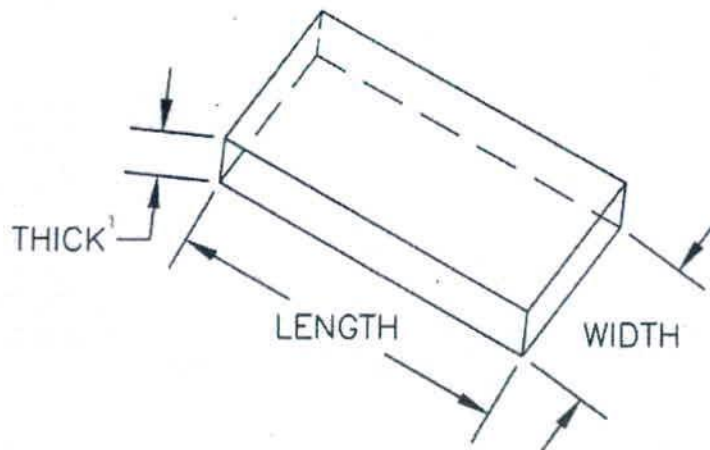


2006/11/30

DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>JS</i>	DRAWING NO. D6101	Rev. A SHEET 1 OF 1
DATE 01.03.30		TITLE SADDLE BILLET, 7075	SCALE NTS
A	01.03.30	NEW ISSUE	

SPECIFICATION CONTROL DRAWING

RELEASED
01.04.23 *#*

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length

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SHIP TO: A M CASTLE & CO 3400 NO. WOLF ROAD FRANKLIN PARK, IL 60131
SOLD TO: AM CASTLE & CO 3400 NO. WOLF ROAD FRANKLIN PARK, IL 60131

KAISER ALUMINUM

Trentwood Works - Spokane, WA 99216
 Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
 4080392

CUSTOMER PO NUMBER: 01-83475		WORK PACKAGE:		CUSTOMER PART NUMBER: 6873 A97075-60		SHIP RUN/LOAD ID: 100828/18		GOV'T CONTRACT NUMBER:	
KAISER ORDER NO: 1042200	LINE ITEM: 1	SHIP DATE: 9-NOV-2006	ALLOY: 7075	CLAD: BARE	TEMPER: T7351	PRODUCT DESCRIPTION: MILL FINISH PLATE			
WEIGHT SHIPPED: 7276 LB	QUANTITY: 4 PCS EST.	B/L NUMBER: 2010362	GAUGE: 2.5000 IN		WIDTH: 48.500 IN	LENGTH: 147.000 IN			

Certified Specifications

AMS 4078/RevF
 ASTM B 209/Rev06
 BSS 7055/RevA
 GSS16100/RevG
 PS 21211/RevJ

AMS-QQ-A-250/12
 ASTM B 594/Rev02
 CSTI 006/RevC
 MIL-STD-2154

AMS-STD-2154
 BAC 5439/RevH
 DPS 4.713/RevN/AmdAF
 MMS 159/RevN

Test Code: 4297

Test Results

Lot: 378703A3 Cast 933

Drop 16

Ingot 1

Tensile:	Temper T7351	Dir / # Tests LT / 2 (Min:Max)	Ultimate KSI (MPA) 89.9 : 70.0 (482 : 483)	Yield KSI (MPA) 58.3 : 58.7 (402 : 405)	Elongation % 10.8 : 11.6
Conductivity %IACS :			42.4 Min	42.8 Max	
(MS/M) :			24.6 Min	24.8 Max	

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	
Actual	0.08	0.17	1.42	0.01	2.48	0.20	5.60	0.01	0.01	0.01	TOT	0.02

ALLOY LIMITS

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
7075 MIN	0.00	0.00	1.20	0.00	2.10	0.18	5.10	0.00	0.00	0.00	EACH	0.05
MAX	0.40	0.50	2.00	0.30	2.90	0.28	6.10	0.20	0.05	0.05	TOT	0.15

Aluminum Remainder

CASTLE METALS FP
 DATE REC'D 11.15.06 6873
 APPROVED BY: SW

KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
4080392

TEST NOTES

Metal represented by this test report was immersion
ultrasonically tested from one side and meets the Class A
and Class B requirements of all specifications referenced
on this test report.

CERTIFICATION

KAISER ALUMINUM & CHEMICAL CORPORATION (KAISER) HEREBY CERTIFIES THAT METAL SHIPPED UNDER THIS ORDER WAS MELTED AND MANUFACTURED IN THE U.S.A.
AND HAS BEEN INSPECTED, TESTED, AND FOUND IN CONFORMANCE WITH THE REQUIREMENTS OF THE APPLICABLE SPECIFICATIONS AS INDICATED HEREIN. ALL METAL WHICH
IS SOLUTION HEAT-TREATED COMPLIES WITH AMS 2772. ANY WARRANTY IS LIMITED TO THAT SHOWN ON KAISER'S STANDARD GENERAL TERMS AND CONDITIONS OF SALE.
TEST REPORTS ARE ON FILE, SUBJECT TO EXAMINATION. TEST REPORTS SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF KAISER
ALUMINUM & CHEMICAL CORPORATION LABORATORY. THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULANT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE
PUNISHED AS A FELONY UNDER FEDERAL LAW. ISO-9001:2000 CERTIFIED

BILL POYNOR, LABORATORIES SUPERVISOR

Bill Poy

